

B-1B

Status Report – March 2004
Wing Shear Bearing Maintenance Repair (SD11)

Contract No. F33657-01-D-2050
Delivery Order No. SD-11

PCO: Jerry Vann
CDRL Number: A00A

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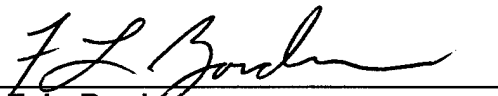
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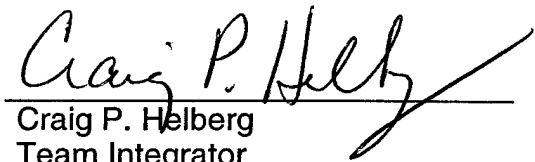
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Air Force PCO: Jerry Vann
CDRL Number: A00A

Prepared by:
Lance Borden

Approved by:


F. L. Borden
Project Team Lead
Shear Bearing Repair CFT


Craig P. Helberg
Team Integrator
B-1B Structures & Flight Sciences

The information in this document was requested by OC-ALC/PSKAB, Tinker AFB, OK 73145-5990 under Government Contract Number F33657-01-D-2050 and is approved for public release; distribution is unlimited. However, it does not necessarily bear the endorsement of the requesting agency.

Date: 02 April 2004

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Long Beach, CA 90807

FOREWORD

The B-1B Structures & Flight Sciences Department of The Boeing Company Integrated Defense Systems Group, Long Beach, California prepared this monthly status report, in support of contract F33657-01-D-2050. This report was authorized by Oklahoma City Air Logistics Center (OC-ALC/PSKAB), Tinker Air Force Base, Oklahoma, under BONE Delivery Order SD11.

SUMMARY

The primary purpose of this report is to provide documentation regarding the status of the Contractor Field Team (CFT) Wing Shear Bearing Maintenance Repair effort at Ellsworth AFB for the period 27 February 2004 through 29 March 2004. Three (3) aircraft were in work during March 2004 with one (1) aircraft completed. The completed aircraft was a combined Wing Shear Bearing (WSB) Repair/Block E Mod (A/C 86-0136). WSB only repair of Aircraft 86-0125, assigned to Ellsworth AFB, was begun on 24 March in a second hangar. This is the second aircraft of the additional 7 B-1 aircraft added to the CFT workload, the first being Edwards AFB flight test A/C 85-0068 recently completed. Currently, twelve (19) aircraft are to be repaired by the Contractor Field Team (CFT) under this delivery order. Two of the eight aircraft scheduled for concurrent WSB / Block E/PC Card modifications have been completed.

STATUS REPORT

The CFT Status Report email, covering the time period from initial SD11 delivery order award on 13 November 2003 to 29 March 2004, is presented in Appendix A. The CFT team has completed eight of nineteen aircraft scheduled under this delivery order. Appendix B presents the overall aircraft schedule with progress as of 29 March 2004. Appendix C shows a table of aircraft designated for Shear Bearing Repair with their scheduled and actual starts and finish dates. Block E mod-WSB repair teleconferences continue as necessary (but at a minimum of once per month) to address any Boeing and/or Customer concerns and actions required to support the concurrent Block E mod-WSB repair CFT work and the scheduling of future aircraft designated for both WSB and/or Block E installs. Appendix D presents man-hours and budget dollars expended on the SD11 delivery order through 25 March 2004 (end of budgetary month). Mesa performance continues to meet or beat Modified Shear Fitting scheduled need dates in support of both Dyess and Ellsworth repair teams. A/C 85-0069 Shear Fitting mod was completed in a record 5 working days!

Appendix A

CFT Status Report

Borden, Lance

From: Borden, Lance
Sent: Monday, March 29, 2004 8:03 AM
To: Borden, Lance; EXT-Gilbert, Greg; 'ext-Steve.Tipton'; 'Ext-Harold Reed'; 'Ext-Larry.Urish'; 'Vann Jerry L Civ OC-ALC/PSKAB'; 'Bryan, Helen K'; Binder, Richard A; 'Ext-2Lt Kimmy Moss'; EXT-Evans, Gavin; EXT-Scott, Wilson A; Chan, Chi; 'Macas Michael J Civ OC-ALC/MABBBA'; 'Jones Gary G Civ OC-ALC/MAB'; 'Hancock Deward E Civ OC-ALC/MABBBA'; 'ext-Gerry Wade (E-mail)'; 'Monroe Kay Civ OC-ALC/PSBP'; 'Barbara.Alexander@tinker.af.mil'; 'James.Geiger@ellsworth.af.mil'; 'Jerry.Densmore@ellsworth.af.mil'; 'Poolaw Marti Civ OC-ALC/PSBMC'
Cc: Degnan, Glen C; Clark, William H; Carver, Lawrence A; 'Stephenson, Robert E'; Heath, Jonathan C; Andrew, Sharon M; Mize, Richard K; Decker, Kenneth V; Reiss, Sandra L; Steadman, Gail V; Romanelli, Jeffrey J; Fierro, Cindy L; Athearn, Stephen E; 'Morris, J. Craig'; Glover, Fred G; Zertuche, Jose M; Scott, Wilson A; Hartmann, Bernard H; Booth, Marcia A; Traugott, John A; Durham-III, George A; Helberg, Craig P; 'gregory.kerr@dyess.af.mil'; Lepo, Peter J; Foster, Dave; Nelson, Steve R; Boler, Michael; Werner, Jon J; 'Navarro, Catarino Q'; Prevost, Glenn; Marshall, Geri A; White, Mace A; Wentz, Jeremy; Ahmadi, Parichehr D; Weiser, Jacklynn M; Reed, Gregory T; 'cate.kauffman@wpafb.af.mil'; Kauffman, Cathy A
Subject: RE: RE: Shear Bearing Repair CFT Status 03/29/04



SD11 Status
32904.pdf (237 KB).

Plan for 03-30-04

- * A/C 86-0125: No new shims required; begin Shr Ftg / Brg installs; start systems restoration.
- * A/C 85-0069: Brg / Shr Ftg removal; measure shims.; prepare to ship ftgs to Mesa.
- * Mesa: A/C 125 (rotatable pool ftgs-Ellsworth): Shr Ftgs should go to machining today (Tue).

03-29-04

- * A/C 86-0125: Brgs & Ftgs installed; down jack today; start systems restoration
- * A/C 85-0069: Panel Press returned on Thurs 3/26; Upper panels removed by Fri 3/27; jacked A/C on Sat. and continued stowing systems. Remove hydro lines today.
- * Mesa: A/C 125 (rotatable pool ftgs-Ellsworth): Should have fittings at Mesa (waiting to hear from Mesa on their status).

Plan for 03-26-04

- * A/C 86-0125: No new shims required; begin Shr Ftg / Brg installs; start systems restoration.
- * A/C 85-0069: Stow what systems can be done with Upper Panels still installed. Press AF for return of Panel removal Press Tool.
- * Mesa: A/C 125 (rotatable pool ftgs-Ellsworth): Shr Ftgs should arrive at Mesa today (Fri.).

03-25-04

- * A/C 86-0125: Jacked A/C yesterday morning; finish Brgs & Ftgs removal and measure; can use 3 of 4 same shims and one shim off previous A/C.
- * A/C 85-0069: Lower Panels removed. Upper panels delayed due to Panel Removal Press Tool being taken by AF for inspection/calibration. Hope to have it back tomorrow or Mon.; team moving over to work A/C 125 heavy.
- * Mesa: A/C 065 (rotatable pool ftgs-Dyess): Customer bought-off and shipped to Dyess: 3/23; received at Dyess 3/24.
- * Mesa: A/C 125 (rotatable pool ftgs-Ellsworth): Ship Shr Ftgs to Mesa today.

Plan for 03-23-04

- * A/C 86-0125: Begin systems stow; deservice hydro; remove hydro lines.
- * A/C 85-0069: Tentatively fly into Ellsworth today; begin WSD/Blk E on Wed.
- * Mesa: A/C 065 (rotatable pool ftgs-Dyess): In clean & paint today; post for customer buyoff tomorrow.

03-22-04

- * A/C 86-0125: Began depaneling today
- * A/C 85-0069: Returned to Dyess after birdstrike on Nose Radome Thurs..R&R was required.
- * Mesa: A/C 136 (rotatable pool ftgs-Ellsworth): Shr Ftgs arrived back at Ellsworth Fri 3/19.

- * Mesa: A/C 065 (rotatable pool ftgs-Dyess): completed machining Fri; complete drilling today.

Plan for 03-19-04

- * A/C 85-0069: Begin WSB Repair; start panel removals.
- * Mesa: A/C 065 (rotatable pool ftgs-Dyess): In machining.

03-18-04

- * A/C 86-0136: Complete Panel Installs today; rolled out of hangar this morning; **A/C Complete.**
- * A/C 85-0069: Due to arrive today and go into prep for WSB repair.
- * Mesa: A/C 136 (rotatable pool ftgs-Ellsworth): Completed mod and Ftgs were shipped back to Ellsworth yesterday 3/17/04.
- * Mesa: A/C 065 (rotatable pool ftgs-Dyess): Should have arrived and go to machining.

Plan for 03-16-04

- * A/C 86-0136: Continue panel installs; WSB ECD: COB 03/18/04.
- * A/C 85-0069: Tentative next A/C for WSB Repair/Blk E Mod to arrive on the 18th and begin prep for input on the 19th.
- Wear Strip restock from Tinker is becoming critical. Harold Reed working issue.
- * Mesa: A/C 136 (rotatable pool ftgs-Ellsworth): Ftgs in drilling today; complete and move to inspection tomorrow.
- * Mesa: A/C 065 (rotatable pool ftgs-Dyess): Should arrive Mesa Tue 3/16.

03-15-04

- * A/C 86-0136: Perform wing sweeps this morning; begin panel reinstalls & install Kevlar Curtains.
- * Mesa: A/C 136 (rotatable pool ftgs-Ellsworth): Complete machining; move to drilling; ECD: 03/19/04.

Plan for 03-12-04

- * A/C 86-0136: Continue systems restoration; prep for hydro servicing; prep for wing sweeps.
- * Mesa: A/C 136 (rotatable pool ftgs-Ellsworth): Ftgs in machining today.

03-11-04

- * A/C 86-0136: New shim completed yesterday; completed Brg/Ftg installs; start systems restoration/dejack today
- * Mesa: A/C 120 (rotatable pool ftgs-Dyess): Arrived Dyess Tue
- * Mesa: A/C 136 (rotatable pool ftgs-Ellsworth): Ftgs arrived at Mesa yesterday (Wed)

Plan for 03-09-04

- * A/C 86-0136: If no shims required, install Brgs / Shr Ftgs.
- * Mesa: A/C 136 (rotatable pool ftgs-Ellsworth): Ftgs should arrive Mesa today (Tues).

03-08-04

- * A/C 86-0136: Completed Brg/Ftg removals; measuring fittings and prep for shipment to Mesa this afternoon.
- * Mesa: A/C 120 (rotatable pool ftgs-Dyess): Arrive Dyess today or tomorrow

Plan for 03-05-04

- * A/C 86-0136: Complete Brg/Ftg removals; measure fittings and prep for shipment to Mesa.
- * Mesa: A/C 120 (rotatable pool ftgs-Dyess): Post for Customer buy-off; try to get signatures and ship Fri. afternoon..otherwise out of Mesa on Monday.

03-04-04

- * A/C 86-0136: No progress the last 2 days due to base closure and then snow removal operations..Back on the jet today; complete Kevlar Curtain removals; start Brg/ Shgr Ftg removals.
- * Mesa: A/C 120 (rotatable pool ftgs-Dyess): Ftgs in Inspection today

Plan for 03-02-04

- * A/C 86-0136: Should have roads cleared and base open; Continue stow systems; start Brg/Ftg removal.
- * Mesa: A/C 120 (rotatable pool ftgs-Dyess): Ftgs in drilling; ECD for mod is 03/10 (should beat that date).

03-01-04

- * A/C 86-0136: No progress today..Base is closed due to snow storm. Jacked A/C late on Fri 2/27
- * Mesa: A/C 120 (rotatable pool ftgs-Dyess): Machining complete

Plan for 02-27-04

- * A/C 86-0136: Continue panel removals.
- * Mesa: A/C 120 (rotatable pool ftgs-Dyess): Ftgs in machining.

02-26-04

- * A/C 86-0136: A/C arrived from Dyess yesterday afternoon; completed prep and put in hangar; begin panel removals

today.

* Mesa: A/C 120 (rotatable pool ftgs-Dyess): Send to machining

Plan for 02-24-04

* A/C 86-0136: Fly A/C into Ellsworth; arrive about noon; Prep for WSB; begin repair Wed. morning.

* Mesa: A/C 120 (rotatable pool ftgs-Dyess): Shr Ftgs arrive at Mesa.

02-23-04

* A/C 85-0068: **A/C completed** Saturday morning 2/21/04.

* A/C 86-0136: Complete reinstall of 2 windows by COB today at Dyess.

* Mesa: A/C 120 (rotatable pool ftgs-Dyess): Send from Dyess to Mesa this afternoon.

Plan for 02-20-04

* A/C 85-0068: Complete panel installs; aerofare closeout strips; A/C Complete at COB (tentative).

* Mesa: A/C 068 (rotatable pool ftgs-Ellsworth): Completed Paint and ID; post for DCMA buyoff ; ship to Ellsworth.

02-19-04

* A/C 85-0068: Completed wing sweeps on Tues; started Kevlar Curtain installs; installing panels today.

* Mesa: A/C 068 (rotatable pool ftgs-Ellsworth): Fittings in inspection.

Plan for 02-17-04

* A/C 85-0068: Complete prep for wing sweeps; do wing sweeps. Repair ECD: COB 12/20/04

* Mesa: A/C 068 (rotatable pool ftgs-Ellsworth): Ftgs to Drilling today. ECD: 12/20/04

02-16-04

* A/C 85-0068: Complete restoring systems and checkouts; completed down jack.

* Mesa: A/C 068 (rotatable pool ftgs-Ellsworth): Machining completes today.

Plan for 02-13-04

* A/C 85-0074: Complete Panel installs and Aerofare cover strips; **A/C complete.**

* A/C 85-0068: Complete Brg and Shear Fitting install RH; prep for down jack; start restoring systems.

* Mesa: A/C 068 (rotatable pool ftgs-Ellsworth): Ftgs should arrive Mesa yesterday; go to machining today.

02-12-04

* A/C 85-0074: Wing sweep successful yesterday morning; began curtain installs; began panel installs.

* A/C 85-0068: Brgs out Shim for upper RH completed by back shop late yesterday; LH Brg / Shr Ftg installed yesterday; will do RH install tomorrow after finish of A/C 074. Fittings shipped to Mesa.

* Mesa: A/C 074 (rotatable pool ftgs-Ellsworth): All processes completed shipped 02/11 to Ellsworth.

* Mesa: A/C 103 (rotatable pool ftgs-Dyess): All processes completed shipped 02/11 to Dyess.

Plan for 02-10-04

* A/C 85-0074: Install Kevlar Curtains; begin panel installs.

* A/C 85-0068: Complete Brg and Shear Fitting removals; measure Shr Ftgs and determine shim requirements; ship Ftgs to Mesa for mod; prep rotatable pool Shr Ftgs for install.

* Mesa: A/C 074 (rotatable pool ftgs-Ellsworth): complete drilling tomorrow; move to inspection tomorrow ; ECD 2/13/04.

* Mesa: A/C 103 (rotatable pool ftgs-Dyess): Ftgs complete drilling; move to inspection; ECD 2/12/04.

02-09-04

* A/C 85-0074: Service hydro this morning and perform wing sweeps.

* A/C 85-0068: Completed systems stow; jacked A/C over the weekend; began Brg removals.

* Mesa: A/C 074 (rotatable pool ftgs-Ellsworth): Machining complete; begin drilling following A/C 103.

* Mesa: A/C 103 (rotatable pool ftgs-Dyess): Ftgs completed machining; being drilled today.

Plan for 02-06-04

* A/C 85-0074: Continue systems reinstalled; prep for wing sweeps.

* A/C 85-0068: Continue panel removals; start systems stow.

* Mesa: A/C 074 (rotatable pool ftgs-Ellsworth): Ftgs in machining; ECD 2/16/04.

* Mesa: A/C 103 (rotatable pool ftgs-Dyess): Ftgs complete machining late today; move to drilling Mon.; ECD 2/13/04.

02-05-04

* A/C 86-0102: COC today.

* A/C 85-0074: Dejacked yesterday; begin systems reinstall.

* A/C 85-0068: Flew into Ellsworth from Edwards-arrived Wed. 13:00; Prep'd and put in hangar; start panel removals.

* Mesa: A/C 074 (rotatable pool ftgs-Ellsworth): Ftgs start machining today; ECD 2/16/04.

* Mesa: A/C 103 (rotatable pool ftgs-Dyess): Ftgs started machining ahead of A/C 074; ECD 2/13/04. Appendix A

02/03.

- * A/C 85-0074: Complete Bearings / Shr Ftgs installs; begin restoration of systems; prep for deacking.
- * A/C 85-0068: Fly into Ellsworth from Edwards late Tues. or Weds. morning.
- * Mesa: A/C 102 (rotatable pool ftgs-Ellsworth): Post for buyoff; crate and ship today to Ellsworth.
- * Mesa: A/C 074 (rotatable pool ftgs-Ellsworth): Ftgs should be in machining.
- * Mesa: A/C 103 (rotatable pool ftgs-Dyess): Ftgs should be at Mesa today; move to machine shop

02-02-04

- * A/C 86-0102: Complete panel aerofare cure today; **A/C complete** COB today.
- * A/C 85-0074: Begin Bearings / Shr Ftgs installs.
- * Mesa: A/C 102 (rotatable pool ftgs-Ellsworth): Complete paint and ID today.
- * Mesa: A/C 074 (rotatable pool ftgs-Ellsworth): Ftgs should be at Mesa today; move to machine shop.

Plan for 01-30-04

- * A/C 86-0102: Continue to install upper and lower panels; will work Sat. to complete aircraft repair by COB Mon. 02/02/04.
- * A/C 85-0074: Determine if shims required..if not, begin Bearing / Shr Fitting installs.
- * Mesa: A/C 102 (rotatable pool ftgs-Ellsworth): Complete drilling by Monday; go to Inspection; ECD:02/04/04.
- * Mesa: A/C 074 (rotatable pool ftgs-Ellsworth): Ftgs should arrive at Mesa today or Monday at the latest.

01-29-04

- * A/C 86-0102: Wing Sweeps complete this morning; begin Kevlar Curtain and panel reinstalls.
- A/C 85-0074: Bearings / Shr Ftgs removed and being measured for shim requirement; package and ship to Mesa.
- * Mesa: A/C 102 (rotatable pool ftgs-Ellsworth): In drilling

Plan for 01-27-04

- * A/C 86-0102: Complete hydro bleed; prep for wing sweeps.
- * A/C 85-0074: Complete fuselage and wing jacking. may carryover to Wed.; begin bearing Shr Fitting removal.
- * Mesa: A/C 102 (rotatable pool ftgs-Ellsworth): Complete machining; in drilling (estimated as I have not got word from Mesa this morning -Mon.-on their progress).

01-26-04

- A/C 86-0102: No new shims required; completed Shr Fitting / Bearing; panel installs over the weekend; began system restoration; down jack today.
- * A/C 85-0074: Continued stow systems; remove hydro lines; finish removing curtains; prep for jacking.
- * Mesa: A/C 102 (rotatable pool ftgs-Ellsworth): In machining (estimated as I have not got word from Mesa this morning on their progress).

Plan for 01-23-04

- * A/C 86-0102: Complete Brg and Mod Shr Ftg installs..Use original Shims; begin to restore systems.
- * A/C 85-0074: Complete panel removals; stow systems; bring down hydro; remove curtains; prep for jacking.
- * Mesa: A/C 102 (rotatable pool ftgs-Ellsworth): Ftgs should arrive at Mesa today

01-22-04

- * A/C 85-0074: Aircraft in hangar but a large fuel leak has been identified (determined to be pre-existing condition). Safety issues have been addressed and direction from AF is OK to proceed with WSB Repair; began panel removals.
- * A/C 86-0102: All systems stowed; hydro lines removed and A/C jacked Tues afternoon; Bearings and Shr Ftgs removed; Fittings measured; will use as display items for General Jumper's visit today; ship Ftgs to Mesa today.
- * Mesa: A/C 073 (rotatable pool ftgs-Ellsworth): Modified Shr Fittings arrived at Ellsworth today.

Plan for 01-20-04

- * A/C 86-0102: Continue panel removals; start systems stow.
- * Mesa: A/C 073 (rotatable pool ftgs-Ellsworth): Complete drilling; go to inspection. ECD: 01/22/04

01-19-04

- * A/C 85-0073: **A/C Completed On Saturday 01/17/04.** COC signoff planned for tomorrow.
- * A/C 86-0102: Prepared aircraft for WSB on Sat. and pulled in hangar; repair starts today.
- * Mesa: A/C 073 (rotatable pool ftgs-Ellsworth): In drilling.

Plan for 01-16-04

- A/C 85-0073: Continue panel installs (A/C complete ECD Sat morning -- 1/17/04).
- * A/C 86-0102: Plan: prep to go into second 'all in hangar' for WSB Repair only -- start panel removals.
- * Mesa: A/C 073 (rotatable pool ftgs-Ellsworth): Complete machining; go to drilling.

01-15-04

- * A/C 85-0073: Working nutplates. Completed wing sweeps yesterday; install Kevlar Curtains; begin upper spring panel installs.
- * A/C 86-0102: Planned to arrive today from FOB -- If it shows up--start prep for WSB repair today.
- * Mesa: A/C 122 (rotatable pool ftgs-Dyess): Completed and shipped to Dyess 01/13 COB.
- * Mesa: A/C 099 (rotatable pool ftgs-Ellsworth): Completed and shipped to Dyess 01/13 COB.
- * Mesa: A/C 073 (rotatable pool ftgs-Ellsworth): Arrived Mesa; gone to machine shop.

Plan for 01-13-04

- * A/C 85-0073: Finish nutplate/panel refurb; power up; service Hydro system; disturbed sys chk; start wing sweeps. (A/C complete ECD is late Friday or Sat morning (1/17/04).
- * A/C 86-0102: Being prepared to go into second 'all in hangar' for WSB Repair only -- start Wed.
- * Mesa: A/C 122 (rotatable pool ftgs-Dyess): Post for Customer buy-off; Ship to Dyess.
- * Mesa: A/C 099 (rotatable pool ftgs-Ellsworth): Complete inspection and paint today; Customer buy-off tomorrow. ECD:1/14/04.

01-12-04

- * A/C 85-0073: Working nutplates. Plan wing sweeps for late Tues or Wed morning
- * Mesa: A/C 099 (rotatable pool ftgs-Ellsworth): Complete drilling today; go to inspection and paint.
- * Mesa: A/C 122 (rotatable pool ftgs-Dyess): Complete inspection and paint today.

Plan for 01-09-04

- * A/C 85-0073: Complete Bearing installs; begin systems restoration; dejack.
- * Mesa: A/C 099 (rotatable pool ftgs-Ellsworth): Complete machining; go to drilling. ECD:1/14/04..This is acceptable to current repair plan.
- * Mesa: A/C 122 (rotatable pool ftgs-Dyess): Complete drilling and go to inspection. ECD:1/13/04..This is acceptable to current repair plan.

01-08-04

- * A/C 85-0073: Ship Shr Ftgs to Mesa today; modified Shr Ftgs installed-no new shims required; working Bearing installs.
- * Mesa: A/C 099 (rotatable pool ftgs-Ellsworth): Received status report from Mesa: Dyess fittings went into work ahead of Ellsworth set. Complete machining today; go to drilling.
- * Mesa: A/C 122 (rotatable pool ftgs-Dyess): Machining completed yesterday; went to drilling

Plan for 01-06-04

- * A/C 85-0073: Complete Bearing and Shr Ftg removals; measure Shr Ftgs and box for shipment to Mesa.
- * Mesa: A/C 099 (rotatable pool ftgs-Ellsworth): Complete machining; go to drillings.
- * Mesa: A/C 122 (rotatable pool ftgs-Dyess): Machining in work.

01-05-04

- * A/C 85-0073: Went into work on 12/29. Complete jacking today; begin Bearing and Shr Ftg removals.
- * A/C 86-0099: On 12/19, wing sweeps were performed. Due to an 'out of rig' condition, not as a result of the WSB repair, the wings swept beyond the 67.5 deg. limit by a couple of degrees (estimated). Inspected WSB repair area for damage and found none. Some damage to other areas was found.(Refer to Wilson Scott for details). Completed the sweeps and systems restoration. All panels reinstalled. WSB repair completed and removed from hangar 12/29. COC signoff today.
- * Mesa: A/C 099 (rotatable pool ftgs-Ellsworth): Should be into machining process (Estimated-no status yet this morning).
- * Mesa: A/C 122 (rotatable pool ftgs-Dyess): Should be starting machining process (Estimated-no status yet this morning).

Plan for 12-19-03

- * A/C 86-0099: Complete down jack; Begin systems restoration.
- * Mesa: A/C 099 (rotatable pool ftgs-Ellsworth): Go to machine shop (no work over Holidays)
- * Mesa: A/C 122 (rotatable pool ftgs-Dyess): Receive fittings from Dyess (no work over Holidays)

12-18-03

- * A/C 86-0099: Brg / Shr Ftg measurements within tolerance for using existing shims; installed new Brgs / rotatable Shr Ftgs yesterday; waiting for AGE shop support to down jack today.
- * Mesa: A/C 083 (rotatable pool ftgs-Ellsworth): shipped to Ellsworth 12/16..they arrived there yesterday.
- * Mesa: A/C 099 (rotatable pool ftgs-Ellsworth): Receive Shear Ftgs from Ellsworth today.

Plan for 12-16-03

* A/C 86-0099: Complete Brg / Shr Ftg removals; measure Shr Ftgs and prep for shipment to Mesa; ship either today or tomorrow 12/17.

* Mesa: A/C 083 (rotatable pool ftgs-Ellsworth): go to inspection; then to Paint/ID;ECD for overall process: 12/17.

12-15-03

* A/C 86-0099:Kevlar Curtains removed; jack aircraft today; start Brg / Shr Ftg removals.

* Mesa: A/C 059 (rotatable pool ftgs-Dyess): Mod'd Ftgs arrived at Dyess.

* Mesa: A/C 066 (rotatable pool ftgs-Ellsworth): Mod'd Ftgs arrived at Ellsworth.

* Mesa: A/C 083 (rotatable pool ftgs-Ellsworth): Complete drilling today.

Plan for 12-12-03

* A/C 86-0099: Complete panel removals; begin to stow flt cntrls;electrical; start hydro line removal.

* Mesa: A/C 059 (rotatable pool ftgs-Dyess): ECD for overall process will slip to the right several days..probably 12/15.

* Mesa: A/C 066 (rotatable pool ftgs-Ellsworth): Paint/ID; get DCMA buy-off ; ship to Ellsworth.

* Mesa: A/C 083 (rotatable pool ftgs-Ellsworth): Continue Drilling holes; ECD for overall process: 12/17.

12-11-03

* A/C 86-0099: A/C arrived from Dyess yesterday; started panel removals

* Mesa: A/C 059 (rotatable pool ftgs-Dyess): NDRM signed off on RH fitting Tuesday afternoon; goal is to have this set complete by 12/12 but probably more likely 12/15. LH fitting will complete 12/11.

* Mesa: A/C 066 (rotatable pool ftgs-Ellsworth): Finish drilling yesterday; In inspection; ECD for overall process: 12/12.

* Mesa: A/C 083 (rotatable pool ftgs-Ellsworth): Complete machining today; go to drilling process.

Plan for 12-09-03

* A/C 86-0121 (tentative): Begin panel removals.

* Mesa: A/C 059 (rotatable pool ftgs): Disposition dye pen inspect. ECD for overall process will slip to the right several days.

* Mesa: A/C 066 (rotatable pool ftgs): Finish Machining today; Go to Drilling process; ECD for overall process: 12/12.

* Mesa: A/C 083 (rotatable pool ftgs): Begin machining after A/C 066 fittings.

12-08-03

* A/C 85-0083: Final panel installs and aerofare today. **A/C complete COB today.**

* Mesa: A/C 059 (rotatable pool ftgs): Complete hole drilling today; NDRM written against RH fitting for machining defect in flange tip & radius. Disposition to clean up and dye pen inspect.

* Mesa: A/C 066 (rotatable pool ftgs): Finish Machining today; Go to Drilling process; ECD for overall process: 12/12.

* Mesa: A/C 083 (rotatable pool ftgs): Thru receiving ;go to machine shop.

Plan for 12-05-03

* A/C 85-0083: Complete install of Ftgs/Brgs; install hydro lines; restore flight controls and electrical; down jack. Prep for Wing Sweeps; Will work Sat. to catchback schedule. ECD this A/C: COB 12/09.

* Mesa: A/C 059 (rotatable pool ftgs): Complete hole drilling Mon. 12/8; ECD for overall process: 12/10.

* Mesa: A/C 066 (rotatable pool ftgs): Go into Machining today; complete maching 12/8; ECD for overall process: 12/12.

* Mesa: A/C 083 (rotatable pool ftgs): Go to machining after A/C 066 fittings: 12/8.

12-04-03

* A/C 85-0083: Measuring device was in PMEL for calibration. Worked with AF to get the job expedited to complete COB yesterday. Did trial install of fittings with production shims yesterday. Looked good, but could not verify actual gap dimensions. Tore assy's back down to measure fitting heights per SOW. Start Shr Ftg /Bearing reinstalls today if measurements are within tolerances to use existing shims. Worked panel refurb yesterday. Shr Fittings shipped to Mesa yesterday (12/3).

* Mesa: A/C 059 (rotatable pool ftgs): Complete machining today; move to hole drilling.

* Mesa: A/C 066 (rotatable pool ftgs): Move fittings to machine shop.

* Mesa: A/C 083 (rotatable pool ftgs): Arrive Mesa today

Plan for 12-02-03

* A/C 85-0083: Complete Shr Ftg removals; measure Shr Ftgs for shim requirements; box Shr Ftgs and ship to Mesa.

* Mesa: A/C 059 (rotatable pool ftgs): Go into Machining first (before A/C 066) due to earlier need date.

* Mesa: A/C 066 (rotatable pool ftgs): Go into work after A/C 059.

12-01-03

* A/C 85-0083: Began work on Nov 25th; panels removed, systems stowed, hydro drained; Nov 26: hydro lines removed, Kevlar Curtains removed, jacked A/C. Begin to remove Bearings / Shr Fittings today.

* Mesa: A/C 066 (rotatable pool ftgs): IWA placement last Wed morning; Fittings on dock this morning at Mesa (waiting for verification).

* Mesa: A/C 059 (rotatable pool ftgs): IWA placement last Wed morning; Fittings on dock this morning at Mesa (waiting for

verification).

Plan for 11-25-03

- * A/C 85-0066: Complete spring panel and cover strip installs and aerofare; move out of hangar; **A/C complete.**
- * A/C 85-0083: Prep. A/C 85-0083 for start of WSB repair; bring in hangar.
- * Mesa: A/C 066 (rotatable pool ftgs): IWA placement expected today (Tue); pending word to Ellsworth to send Shr Ftgs.
- * Mesa: A/C 059 (rotatable pool ftgs): IWA placement expected today (Tue); pending word to Dyess to send Shr Ftgs.

11-24-03

- * A/C 85-0066: Wing sweeps successfully completed Friday; installed Kevlar Curtains; complete installation of panels today.
- * Mesa: A/C 066 (rotatable pool ftgs): IWA placement inwork; hold Shear Fittings at EAFB and Dyess until IWA in place.

Plan for 11-21-03

- * A/C 85-0066: Perform wing sweeps; finish refurb of panels; install Kevlar Curtains; begin panel installs; A/C ECD 11/24
- * A/C 85-0083: Tentatively the next A/C set to start repair effort on 11/25.
- * Mesa: A/C 066 (rotatable pool ftgs): IWA placement inwork.

11-20-03

- * A/C 85-0066: Shr Ftg measurements completed..existing shims OK to use; Bearings and Shear Fittings installed; began systems resoration yesterday; installed hydro; servicing complete today;down jack today and prep for wing sweeps.
- * Mesa: A/C 066 (rotatable pool ftgs): IWA placement inwork; hold Shear Fittings at EAFB until IWA in place.

Plan for 11-18-03

- * A/C 85-0066: Work panel refurbishment; machine shims (if required);
- * Mesa: A/C 066 (rotatable pool ftgs): IWA placement inwork.

11-17-03

- * A/C 85-0066: Started work on 11/13. Completed all panel removals, systems stow, hydro deservice and line removal, Kevlar curtain removal; removed Bearings and Shear Fittings; measure for shim requirements today; hold Shear Fittings at EAFB until we work out plan with Mesa (IWA in place).
- * Mesa: A/C 066 (rotatable pool ftgs):IWA placement inwork.

Lance Borden

Team Lead

B-1B Flight Sciences

Project Team Lead

Shear Brg Repair CFT

Wing Pivot Brg Replacement

PH 562-982-2657

FAX 562-982-9327

Appendix B

CFT Aircraft Repair Schedule

ELLSWORTH CFT WING SHEAR - SD11		2003			2004														
		Oct	Nov	Dec	Jan	Feb	Mar	Apr	May	Jun	Jul	Aug	Sep	Oct	Nov	Dec	Jan		
Contract Award (12 a/c)																			
a/c #35 (85-0066)		11/13 ▲ 11/1																	

a/c # 48 Through 55 Are DFT @ Dyess

Appendix C

Table of CFT and DFT In-Work or Completed SD11 Aircraft

**Shear Brg Repair
STATUS
3/29/2004**

Repair # & A/C#		A/C Status	A/C home base	Planned Start Date	Revised Start Date	Actual Start Date	Planned Complete	Revised Complete	Actual Complete
Ellsworth									
35* (1)	85-0066	Complete	Ellsworth	11/07/03	11/13/03	11/13/03	11/25/03		11/26/03
36 (2)	85-0083	Complete	Ellsworth	11/24/03		11/26/03	12/11/03	12/09/03	12/09/03
37 (3)	86-0099	Complete	Ellsworth	12/09/03		12/10/03	12/26/03		12/29/03
38 (4)	85-0073	Complete	Dyess	12/22/03	12/26/03	12/29/03	01/13/04	01/17/04	01/17/04
39 (5)	86-0102 #	Complete	Ellsworth	01/19/04		01/19/04	02/11/04	02/04/04	02/03/04
40 (6)	85-0074	Complete	Dyess	01/22/04**		01/22/04	02/13/04		02/13/04
61 (7)	85-0068 #	Complete	Edwards	02/05/04		02/05/04	02/23/04		02/21/04
41 (8)	86-0136	Complete	Dyess	02/19/04**	02/25/04	02/26/04	03/15/04	03/18/04	03/18/04
42 (9)	85-0069	In Work	Dyess	03/17/04**	03/24/04		04/08/04	04/14/04	
43 (10)	85-0061	Tentative	Dyess	04/13/04**			05/04/04		
44 (11)	TBD	Tentative	Dyess	05/10/04**			06/02/04		
45 (12)	TBD	Tentative	Dyess	06/05/04**			06/28/04		
46 (13)	TBD	Tentative	Dyess	06/30/04**			07/22/04		
47 (14)	TBD	Tentative	Dyess	7/26/04**			08/16/04		
56 (15)	86-0125 #	In Work	Ellsworth	03/22/04			04/06/04		
57 (16)	85-0087 #	Tentative	Ellsworth	04/07/04			04/22/04		
58 (17)	86-0121 #	Tentative	Ellsworth	04/23/04			05/08/04		
59 (18)	85-0079 #	Tentative	Ellsworth	05/09/04			05/24/04		
60 (19)	86-0130 #	Tentative	Ellsworth	05/25/04			06/11/04		

* Total A/C repaired or planned for repair since program inception.

Second hangar to be incorporated

** WSB concurrent with Blk E (8 Dyess A/C)

Dyess									
48	85-0059	Complete	Dyess	ALL DATES SHOULD COME FROM DEPOT AT TINKER AFB					
49	86-0122	Complete	Dyess						
50	86-0103	Complete	Dyess						
51	86-0120	Complete	Dyess						
52	85-0065	Complete	Dyess						
53	86-0119	In Work	Dyess						
54	TBD	Tentative	Dyess						
55	TBD	Tentative	Dyess						

Appendix D

Cost Report

**SD11 ACTUAL DOLLARS BY FUNCTION
AS OF: MARCH 25, 2004**

Function	Total \$\$
Proposal Prep	3,804
Financial Supt	21,523
Ellsw Engr'g	30,016
Ellsw Log	110,288
Ellsw Mat'l	37,625
QA (Long Bch)	19,222
Dyess Engr	88,394
Dyess Log	19,761
Dyess Matl	18,250
CFT Mech's	424,419
QA (Ellsworth)	58,308
Ellsw Trvl	35,251
Dyess Trvl	11,723
CAP	501,326
MESA	79,994
TOTAL	\$ 1,459,904
No Prop Prep	\$ 1,456,100

**SD11 ACTUAL HOURS BY FUNCTION
AS OF: MARCH 25, 2004**

Function	Total Hrs
Proposal Prep	30.2
Financial Supt	206.9
Ellsw Engr'g	233.6
Ellsw Log	1,555.4
Ellsw Mat'l	365.2
QA (Long Bch)	224.0
Dyess Engr	684.3
Dyess Log	283.9
Dyess Matl	147.7
CFT Mech's	6,066.8
QA (Ellsworth)	812.6
Ellsw Trvl	-
Dyess Trvl	-
CAP	993.0
MESA	874.3
TOTAL	12477.9
No Prop Prep	12447.7